Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

Form No.	CNC/QA/FM/02
Rev. No.	01
Rev. Date	31-07-2013

Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		13651	33/50
2	Machined By		V.T.L M/c Shop	Dry No. 18.2, 450
3	Pallet Die No.		13158 (3.0) MM	Reo 200
4	Die Category	Drg. No.	Jew	
5	Out Side Diameter	Drg. No.	730 MM, Step OD = 743 MM / 743.4 MM	
6	Inside Diameter	Drg. No.	630.12 MM	Tapper 10°
7	Width of Pellet Die	Drg. No.	290 MM	Step length 23 MM / 23.4
8	Grooves as per Drawing	Drg. No.	15x8x5 MM / 15x8x5 MM	Undercut 6.5 MM / 6.7 MM
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/c Shop	Tapping No of Holes = 16 Both Side
12	Tapping PCD		685 MM	
13	Tapping Hole Diameter		M20 = Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.3 MM Tapping Depth 18.6 MM	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 21/12/24	
1	As per programme no.		—	
2	Gun Drilling Work Completed On		—	
3	Hole Finish In Gun Drilling	Marked	ok	
4	Defective Holes (If Any)		No	

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counter 60°

1	Counter Sinking Depth & Finish	ok						Row = 52
2	External Relief Dia	3.5 MM	Outside (3-3)		Inner			
3	External Relief Depth		23 MM		17 MM			
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		21	12	24			
	Inspected By (Sign) & Date		Ravi 21/12/24					

21/12/24

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner